

Date Thursday, 16/08/2007 7:07:25 AM
 User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CROSSTUBE		
Job Number	: 33979			Part Number	: D2890	
Estimate Number	: 10377			Drawing Number	: D2890 REV B	
P.C. Number	:			Project Number	: N/A	
This Issue	: 16/08/2007		S.O. No. :	Drawing Revision	: B	
Prst Rev.	: NC			Material	:	
First Issue	: / /		Type :	PURCHASED PARTS	Due Date	23/08/2007
Previous Run	: 33978			Qty:	1	Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est. D 05.03.21 Removed Bending procedures KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6008180	Crosstube extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty	Part #	Description
	1	D6008-180	Crosstube extrusion
			Batch <u>B25667</u>
			<u>EL 7-8-16</u>
2.0	BENDING	BENDING MACHINE	
		Comment: BENDING MACHINE	
		1-Bend D2890 as per Dwg D2890 and Folio FT002	<u>EL 7-8-16</u>
3.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<u>EL 07/08/16</u>
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Deburr and Polish	<u>WJ 64</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	<u>WJ 64</u>
		Chemical Conversion Coat as per QSI 005 4.1	<u>EL 07/08/16</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 7:07:25 AM
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 33979

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



W/A
7-8-16

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

Landing gear/cross tube EL 7-8-16

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.17

Job Completion



U 07.08.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

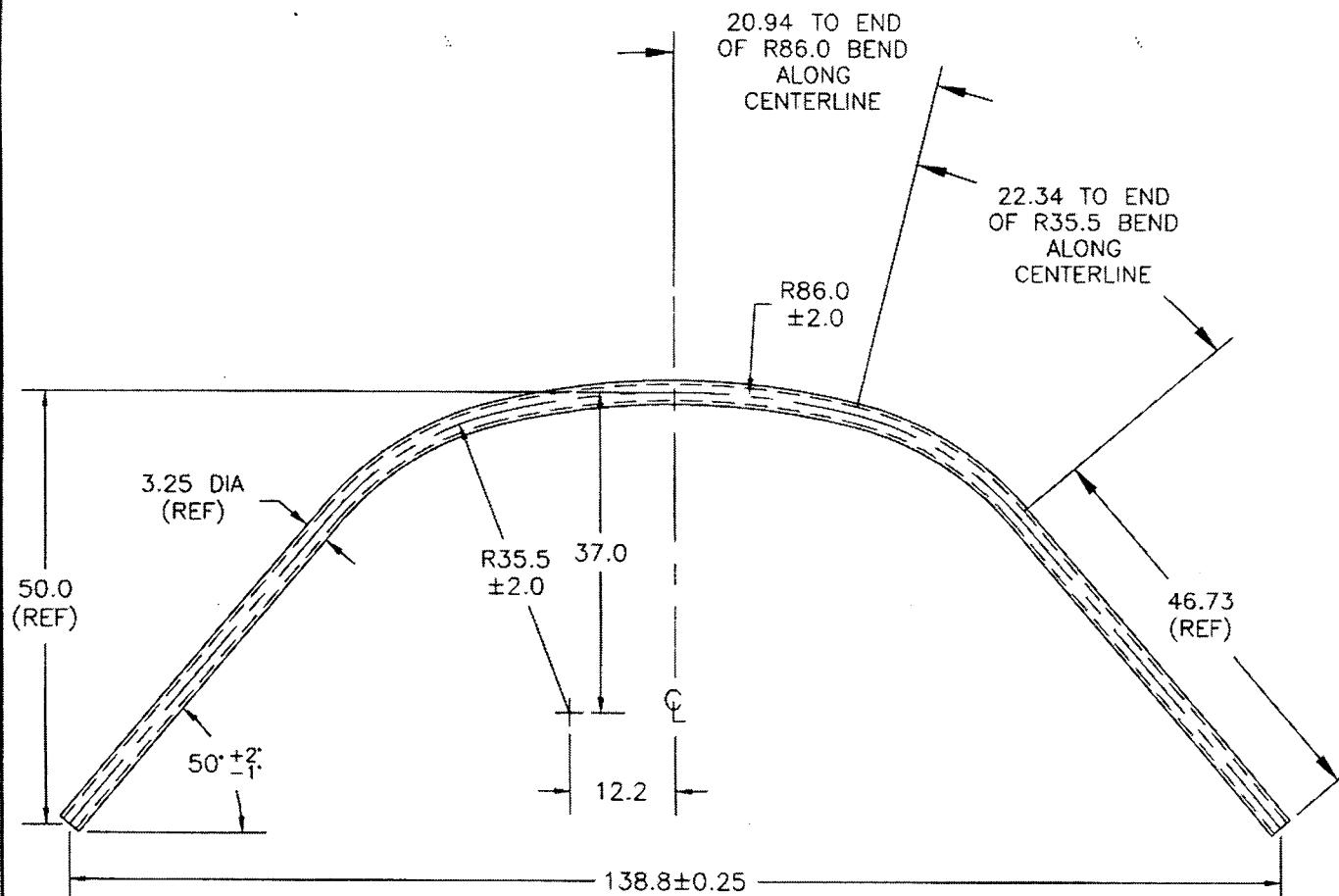
W/0 3/29

DART



RELEASE
02-10-28

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2890	SHEET 1 OF 1
DATE	TITLE		SCALE
02.10.18	AFT CROSSTUBE		1:20
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ($\varnothing 3.25$ OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD**Work Order:**

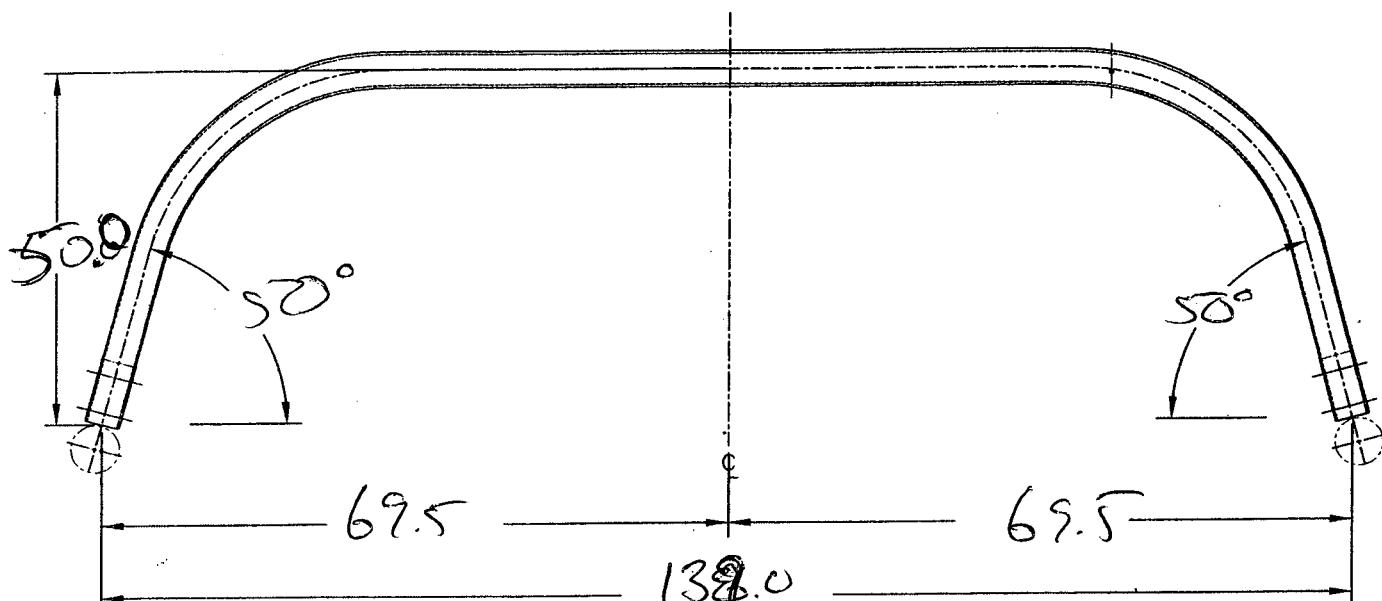
33979

Description: Crosstube Fwd**Part Number:**

D2889

Inspection Dwg: D2889**Rev:** B**Page 1 of 1**

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05

**Comments**

Comments

QC15 Inspection

Date

07/03/16

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	